

Work Order ID 68787



Page 1

Thursday, April 21, 2011 8:11:58 AM

Item ID: D412-698-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Automatic Door Opener, LH/RH

Start Date: 4/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-04-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-698	Rev E

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-023

CHG002

Sulcu/28

110 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/4/27

120 0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Sulcu/28

(+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 4/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-698-023

Location: 10PPP Rev: B

11/4/28 SP

(20)

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/4/28

MF 11-04-28

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 8:12:05 AM

Page 1

Work Order ID: 68787

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN960JD516L

NAS1149D0516J

Purchased

No

120

Each

16.0000

2

4



Washer

Location

Loc Qty

Loc Code

ST347

16

112466

16

D3552-11

Manufactured

No

120

Each

4.0000

1

2



Door Prop

Location

Loc Qty

Loc Code

ST272

4

66649

4

D3594-043

Manufactured

No

120

Each

0.0000

1

2



Floor Doubler Assembly, LH

D3594-044

Manufactured

No

120

Each

2.0000

1

2



Floor Doubler Assembly, RH

Location

Loc Qty

Loc Code

ST234B

2

66653

2

D3594-5

Manufactured

No

120

Each

7.0000

1

2



Door Doubler

Location

Loc Qty

Loc Code

ST234A

7

66651

7

4
11/4/278

2
B67D12SD

B66653

11/4/278 60

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 68787

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

D3622-1

Manufactured No

120

Each

19.0000

2



Ball Stud

Location

Loc Qty

Loc Code

ST070

19

66650

1

67284

18

MS20426AD4-4

Purchased

No

120

Each

3,041.000

2



Rivet

Location

Loc Qty

Loc Code

ST317

3041

116188

3041

MS21073L5

Purchased

No

120

Each

149.0000

1



nut plate

Location

Loc Qty

Loc Code

ST302

100

117395

100

ST303

49

113660

29

116583

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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REFERENCE ONLY**7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS**

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: **E**

Date: 08.05.01

